

Work Order ID 73796-1

Thursday, September 15, 2011 11:05:19 AM

Item ID: D3183-045

Revision ID:

Item Name: Bearing Assembly

Start Date: 9/15/2011 Start Qty: 60.00

Required Date: 9/19/2011 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: *MF*

QC:

Date: 11-09-15

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3183

Rev C1

100



Hardinge

Hardinge CNC Lathe Small

Hardinge CNC LATHE SMALL

0.00

Memo

0.00

Turn D3183-9 Cap as per Folio FA388 Deburr

0.00

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00



Setup Start

Stop

Cust Item ID:

Customer:



For Monday Page 1

Split

14

80.0

Accept

80

80

11/9/16

11/21/16

part 11/21/16

80

Work Order ID 73796

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Item ID: D3183-045

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Start Date: 9/15/2011 Start Qty: 60.00

Required Date: 9/19/2011 Req'd Qty: 60.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Press D3183-5 Bearing into D3183-9 Cap as per Dwg D3183.

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location 234

0.00

Packaging

Memo

0.00

Packaging

9/11/09/21 (14)

8 w/o 21

(14)

(140)

11/9/21

Work Order ID 73796

Thursday, September 15, 2011 11:05:19 AM

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Item ID: D3183-045

Accept

Revision ID:

Item Name: Bearing Assembly

Start Date: 9/15/2011 Start Qty: 60.00

Required Date: 9/19/2011 Req'd Qty: 60.00

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date: SPC (Y/N): Date:

Run Start Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

QC21 - Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

u/a/21
MR
11-09-21

Print

Thursday, September 15, 2011 11:05:16 AM

Work Order ID: 73796

Parent Item: D3183-045

Parent Item Name: Bearing Assembly

Page 1



Comments: IPP A 04.02.18 New issue KJ/DS

Start Date: 9/15/2011

Required Date: 9/19/2011

Start Qty: 60.00

Required Qty: 60.00

Component Item ID/
Item Name

Replacement
Item ID

Mfg/
Purch

Bin
Item

Primary
Location

Last
Location

Route
Seq ID

Unit of
Measure

Qty on
Hand

Qty per Kit

Total
Qty

Qty
Issued

Date
Issued

Status

D3183-5



Bearing

Manufactured No

110

Each

66.0000



1

60

SB 11/09/11

Location

ST235B

71854

Loc Qty

50

B73797

Loc Code

50

ST236

67529

16

68933

1

72295

4

11

130

f

40.3090

0.0333

2.103158



SA 11/12/11

MIDELRINR1.000



Delrin Round Bar 1"

Purchased

No

Location

MAT055

117985

118257

118392

Loc Qty

40.309

0.407

23.902

16

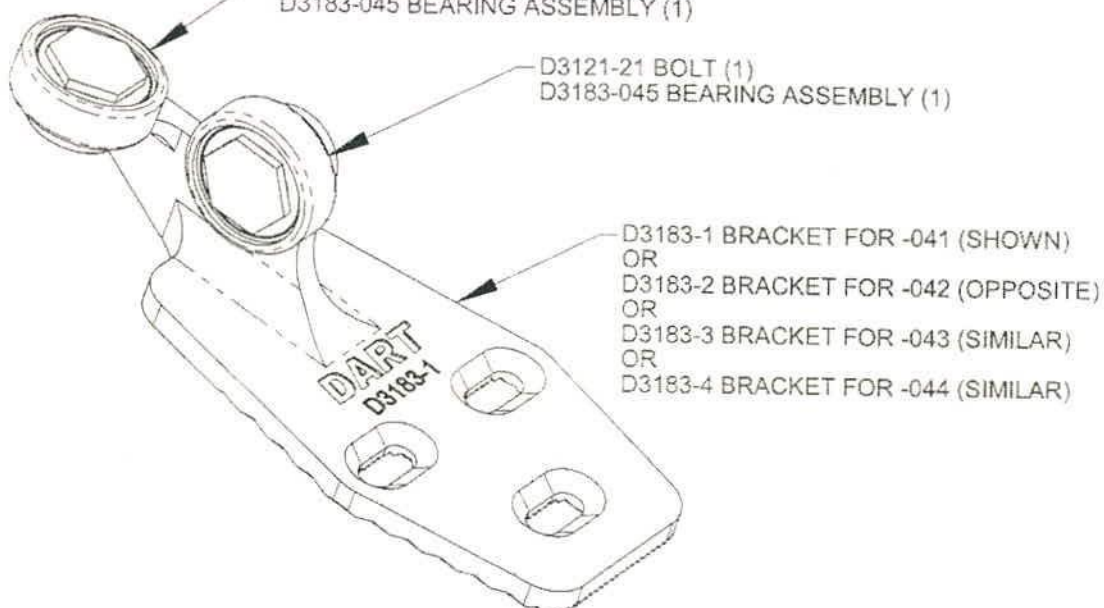
Loc Code

3.5 AA

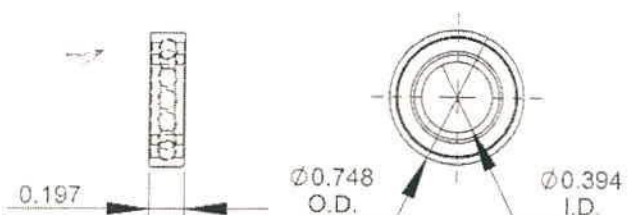


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY ONTARIO CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.07	0.830 WAS 0.850	

DEO ATTACHED

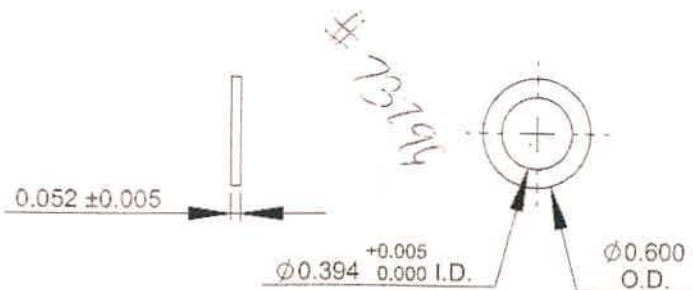


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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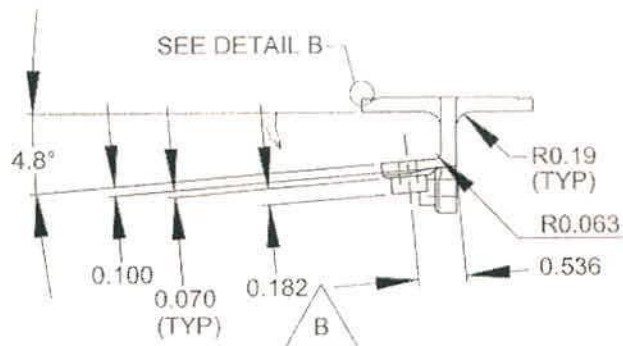
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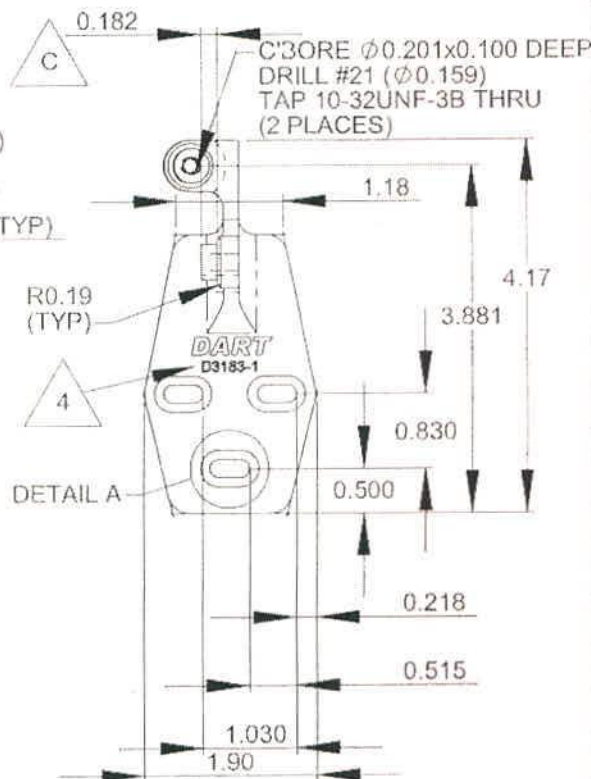
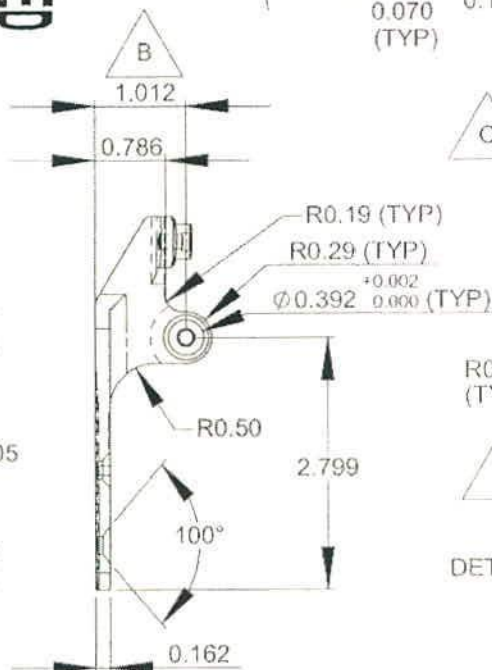
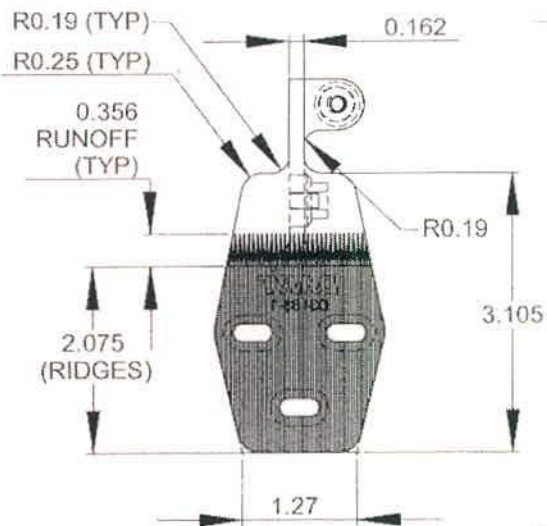


DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 4
DATE	TITLE	DRAWING NO.	SCALE
04.02.17	BRACKET ASSEMBLY	D3183	1:2

SEE DETAIL B



DEO ATTACHED



D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

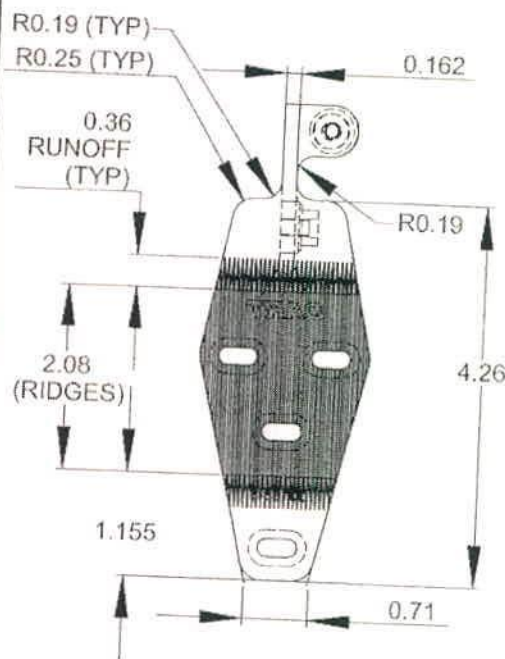
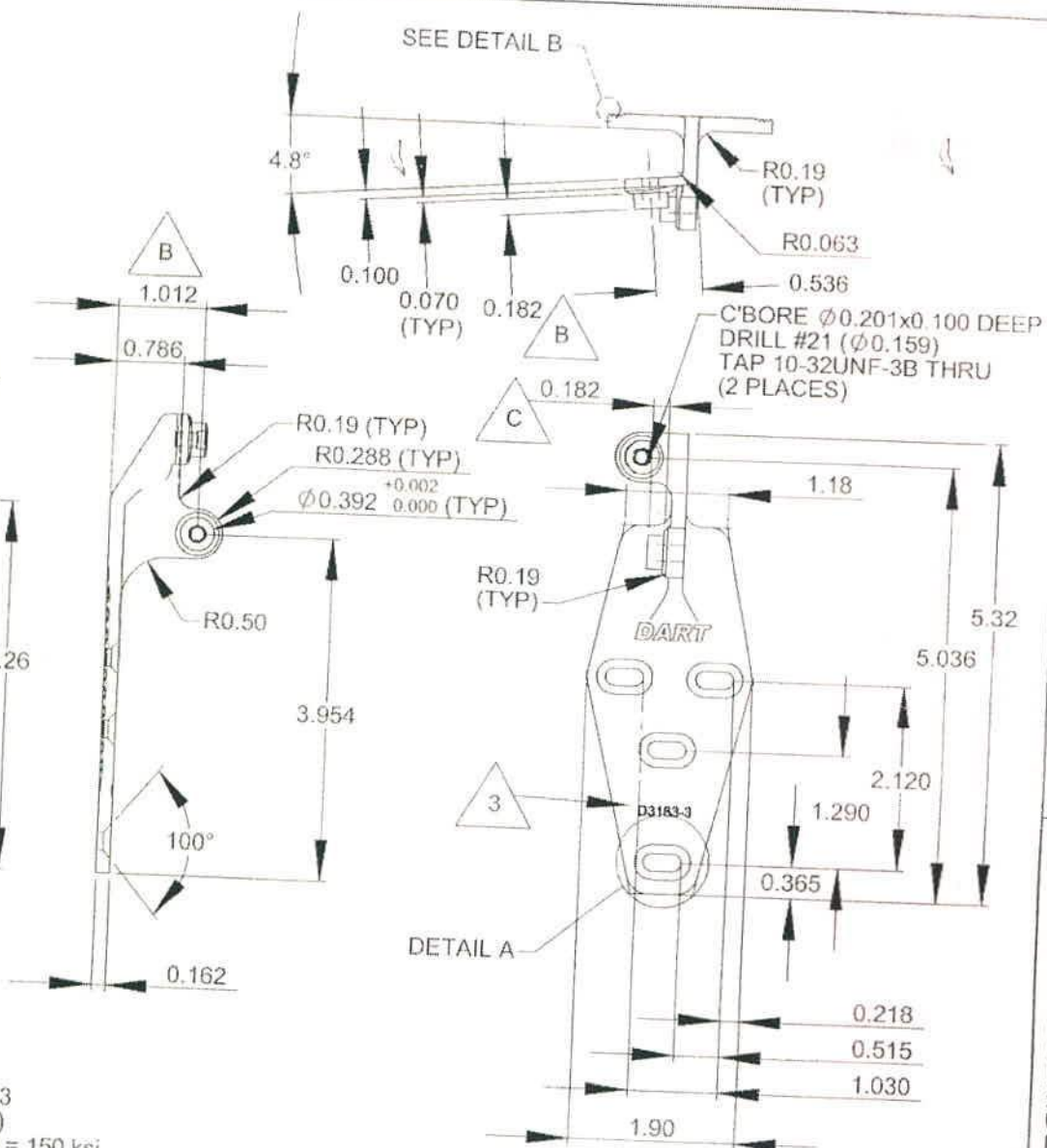
- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE	DRAWING NO.	REV. C
04.02.17	D3183	SHEET 3 OF 4
TITLE	BRACKET ASSEMBLY	SCALE
		1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

DEO ATTACHED

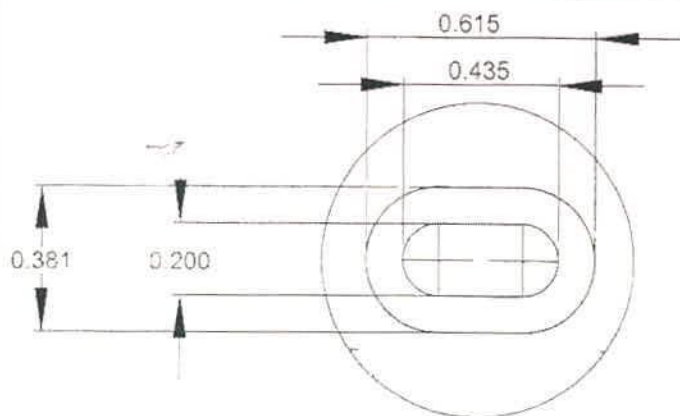
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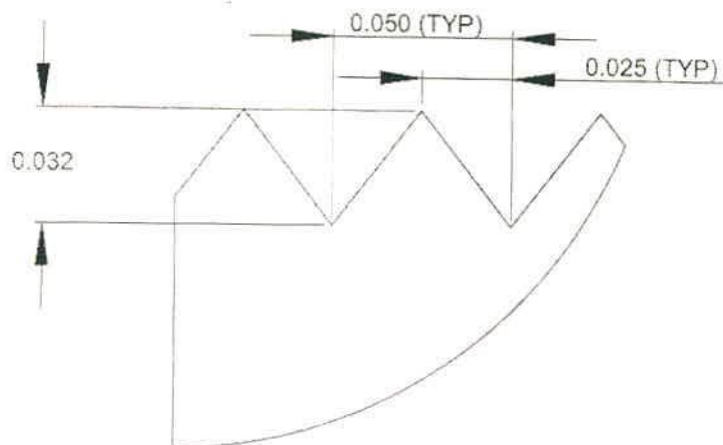
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1



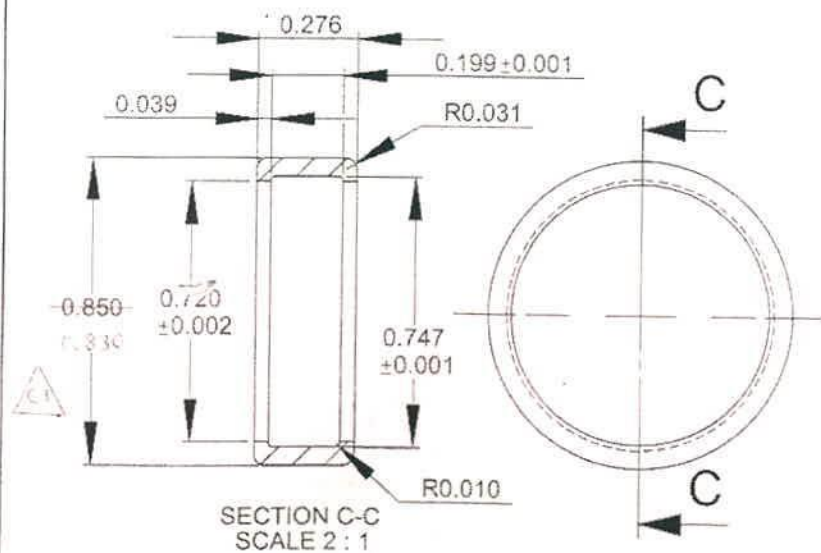
DETAIL A (2 : 1)

RELEASED
04-03-01

DEO ATTACHED



DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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DRAWING NO. D3183	TITLE BRACKET ASSEMBLY	REV.C1	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3183-C1-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 10.05.14	DATE 10.06.30	DATE 10.06.30	DATE 10/06/30		DATE 10/06/30		

D3183-5 BLARING

ADD POSSIBLE SUPPLIER: KML P/N 6800-ZZ

BASIC LOAD RATING REQUIREMENT: Cr = 1720 N (386 lb) MIN [DYNAMIC]
Cor = 840 N (188 lb) MIN [STATIC]

REF PAR 10-012

9622L#

RELEASED
2010-07-22
[Signature]

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